

Date: Wednesday, 12/20/2006 11:59:08 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CAP  
 Job Number : 29993  
 Estimate Number : 12610  
 P.O. Number : N/A Part Number : D29653  
 This Issue : 12/20/2006 S.O. No. : N/A Drawing Number : D2965 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : N/A Material : N/A  
 Due Date : 1/3/2007 Qty: 15 Um: 10 Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev A New Issue 06-12-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2965P Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cap

BATCH: 28959

MS 07/01/08 15

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Turn as per Dwg D2965

MS 07/01/08 15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/01/08 15

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 07/01/08 15

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2965 with DT8538

Deburr and Tumble

SAP 07/01/08 15

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 07/01/08 (15)

PTC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7-1-10	6	① Cop required For jig Fabrication DT8901	DP 7-1-10	7-1-10	1	LE 0701-10	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:59:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 29993

Part Number: D29653

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M102391



Handwritten: 07/01/17 (14)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Handwritten: a.m. 07/01/17

Handwritten: (14)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 ALS7-1032-225 Insert

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

Handwritten: M19393

Handwritten: a.m. 07/01/17 (14)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2965

Handwritten: a.m. 07/01/17 (14)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: ml 07/01/17

Handwritten: (14)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP9

Handwritten: 07/01/17 x14

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 07/01/18 (14)

Job Completion



Handwritten: 07/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

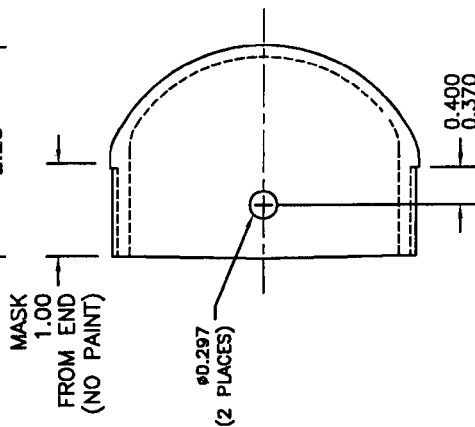
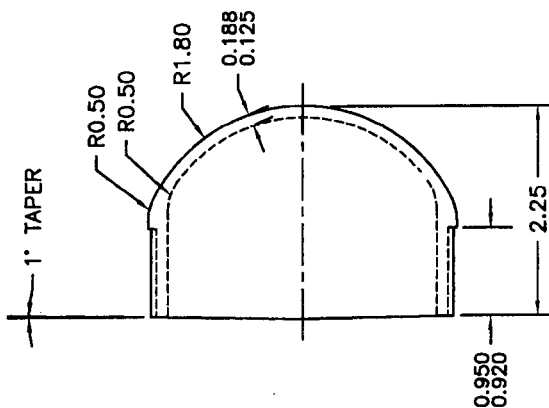
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

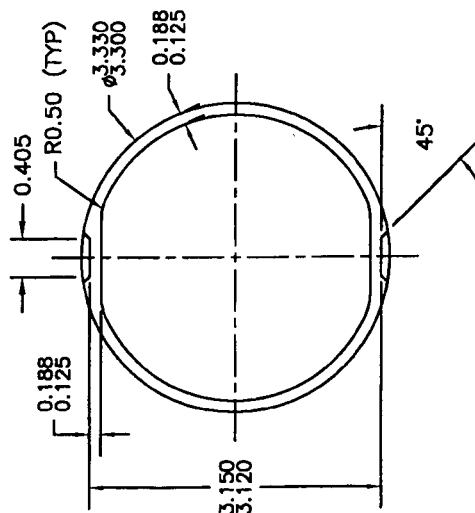
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06.12.12

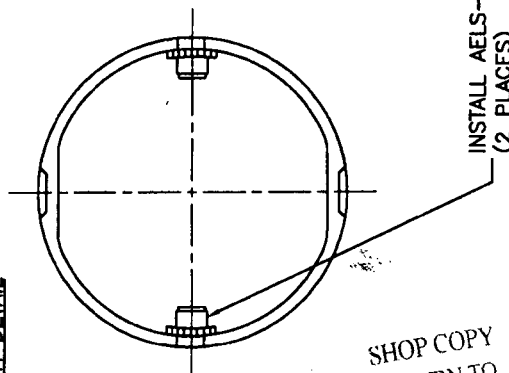
DESIGN P14	DRAWN BY P14	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2965	REV. B SHEET 1 OF 2
DATE 06.11.01		TITLE CAP	SCALE 1:2
A	00.02.24	NEW ISSUE	
B	06.11.01	ADD -3 CAP	



D2965 CASTING DETAIL



D2965 FINISH DETAIL



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29993

D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)  
2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE INCHES

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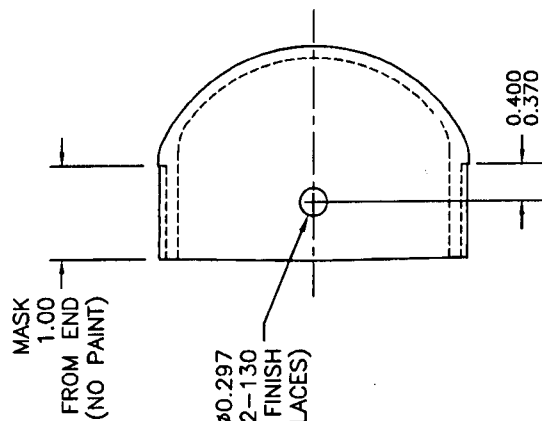
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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2965	REV. B SHEET 2 OF 2
DATE 06.11.01		TITLE CAP	SCALE 1:2

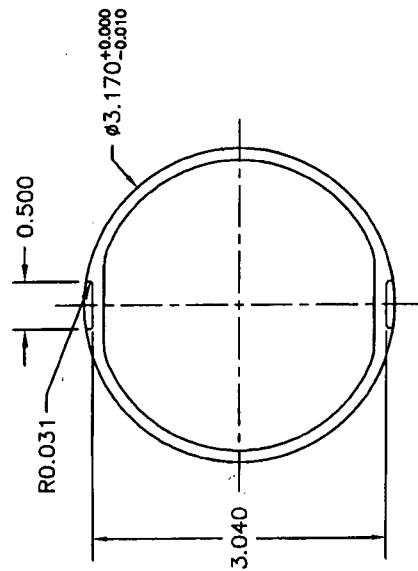
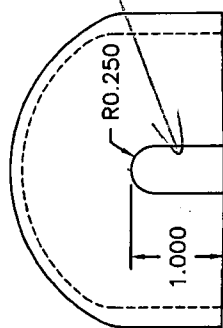
RELEASED

06.12.12 [Signature]



D2965-3 FINISH DETAIL

clean with  
1/2" O3 rad e mill



D2965-3 CAP MACHINING DETAIL  
(MAKE FROM D2965 CAP)

- D2965-3 CAP
- 1) MATERIAL: MAKE FROM D2965 CAP
  - 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE INCHES

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WORK ORDER  
NO. 29993

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